

ASAP Now

Dart Aerospace Ltd.

Date: Tuesday, 15/04/2008 10:15:57 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ANGLE
Job Number : 38600
Estimate Number : 13169
P.O. Number : Part Number : D37301
This Issue : 15/04/2008 S.O. No. : Drawing Number : D3730 REVB
Prsht Rev. : NC Project Number : N/A
First Issue : // Type : MACHINED PARTS Drawing Revision : B
Previous Run : 37843 Material :
Written By : Due Date : 22/04/2008 Qty: 12 Um: Each
Checked & Approved By :
Comment : Est Rev:A 08-01-30 new issue DD verified by:
Est Rev:B 08-03-19 chg to revB ecn 1158 DD verified by:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6A750W125	angle 750 x 750 x.125w
Comment: Qty.: 0.1749 f(s)/Unit Total : 2.0992 f(s) D6207 angle extrusion Batch: M18147		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut to Lenght as per Dwg D3730		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: 1- drill holes as per dwg D3730 2-Deburr		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/04/2008 10:15:57 AM
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Drawing Name: ANGLE

Job Number: 38600

Part Number: D37301

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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3730

2- Deburr if necessary

EB 08/04/16 (12)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/04/16 12

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 08/04/16 x12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/16 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 08/04/16 x12

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/17 (12)

Job Completion



mf 08-04-12

Dart Aerospace Ltd

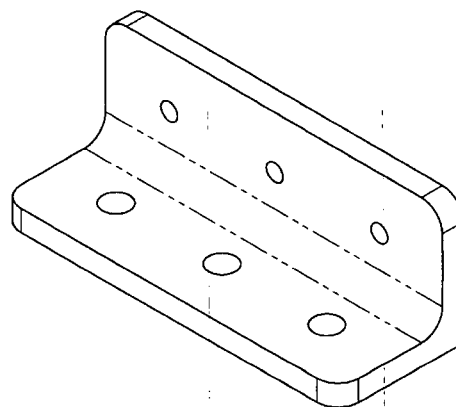
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3730-1 ANGLE B

W/L 38600

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M6061T6A750XW125) B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

B	SHEET 1 NOTES DART SPEC IN MATERIALS UPDATED, ISO VIEW UPDATED, SHEET 2 ZONE C4, Ø0.098 HOLES WERE Ø0.159, ZONE 7B 0.440 DIM WAS 0.450.	AJS	08.03.06
A	NEW ISSUE	AJS	08.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>LE</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>IS</i>	D3730	SHEET 1 OF 2
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>SH</i>	ANGLE	NTS
DATE	08.03.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

08.03.06 M.D.

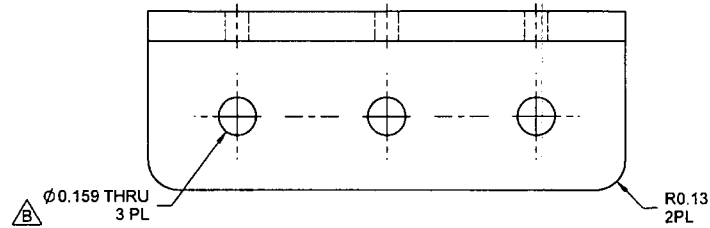
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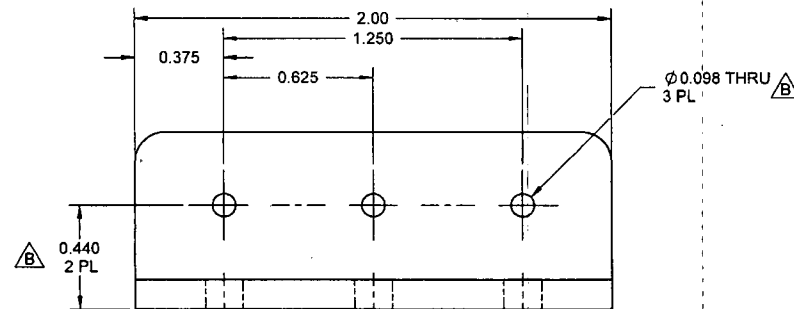
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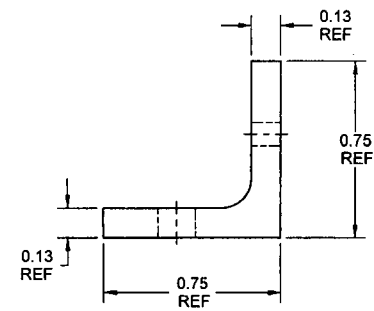


Ø0.159 THRU
3 PL

R0.13
2PL



Ø0.098 THRU
3 PL



D3730-1 ANGLE

08-03-17

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	AS	D3730	SHEET 2 OF 2
APPROVED	HO	TITLE	SCALE
DE APPR.	HL	ANGLE	NTS
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DART AEROSPACE LTD	Work Order:	38600
Description: Angle	Part Number:	D 3730-1
Inspection Dwg: 3230 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ **First Article** ☐ **Prototype**

[illegible]

Measured by:	J.F.	Audited by:	RD	Prototype Approval:	
Date:	08/04/15	Date:	08/04/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

